

Work Order ID 73724

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73724

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Item ID: D3296-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 9/14/11 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/16/11 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 117338

3200F

3230

95 11/10/13

M 11-10-13 (8)

8X 11/10/18

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8

Cust Item ID:

Required Date: 9/16/11 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130 QC3- Inspect Part Finish

0.00

130

QC Memo

Quality Control

8 count 4 all 11/10/11

140 Small Fab

0.00

140

Small Fab Memo

Small Fab Assemble as per Dwg D3296

0.00

4/10/20 8

150 QC5- Inspect part completeness to step on W/O

0.00

150

QC Memo

Quality Control

0.00

8 sub 70

8

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly

Start Date: 9/14/11 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 9/16/11 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

160

Identify as per dwg & Stock Location **S-218** 0.00

160

Packaging

Memo

0.00

Packaging

Sep 11-10-20.

170

QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.00

Quality Control

11/10/24

11/10/21
(8)

Picklist Print

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Work Order ID: 73724
Parent Item: D3296-041
Parent Item Name: Door Assembly

Start Date: 9/14/11

Required Date: 9/16/11

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137 Decal - No Step		Manufactured	No			140	Each	24.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		10							
				74029		10							
				ST006		14							
				72053		14							
D2419 Handle		Manufactured	No			140	Each	16.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		16							
				69732		4							
				74514		12							
D2462 Seal		Manufactured	No			140	f	455.8674	0.3333	2.6664			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST404		455.8674							
				48530		455.8674							
D2728-1 Dart Logo label		Manufactured	No			140	Each	0.0000	0	0			
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	14.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		14							
				72725		6							
				74609		8							

Picklist Print

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Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 9/14/11

Required Date: 9/16/11

Start Qty: 8.00

Required Qty: 8.00

D3161-9
Hinge 17.0"

Manufactured No

100 Each 14.0000

1 8
EB 11/10/13

Location

Loc Qty

Loc Code

ST037

14

72726

8

74610

6

D3296-1

Door Panel

Manufactured No

100 Each 20.0000

1 8
EB 11/10/13

Location

Loc Qty

Loc Code

ST186

20

71719

4

74614

16

D3296-3

Door Panel

Manufactured No

100 Each 24.0000

1 8
EB 11/10/13

Location

Loc Qty

Loc Code

ST186

16

74615

16

ST196

8

71717

8

MS20470AD4-4

Rivet, Universal Head

Purchased No

140 Each 4,190.0000

25 200

Location

Loc Qty

Loc Code

ST139

78

117423

78

ST319

4112

116188

136

116391

66

118614

1910

119109

2000

EB 11/10/13
200

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Shop Packet Print

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Start Date: 9/14/11

Required Date: 9/16/11

Start Qty: 8.00

Required Qty: 8.00

MS20470AD4-6

Purchased

No

100

Each

2,473.0000

1

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1473

117395

32

117887

8

118927

1433

ST320

1000

119109

1000

8
9/11/10/20

8

NAS1149DN632J

Purchased

No

140

Each

795.0000

1

Washer

Location

Loc Qty

Loc Code

ST297

795

118428

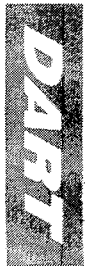
795

8
9/11/10/20
8

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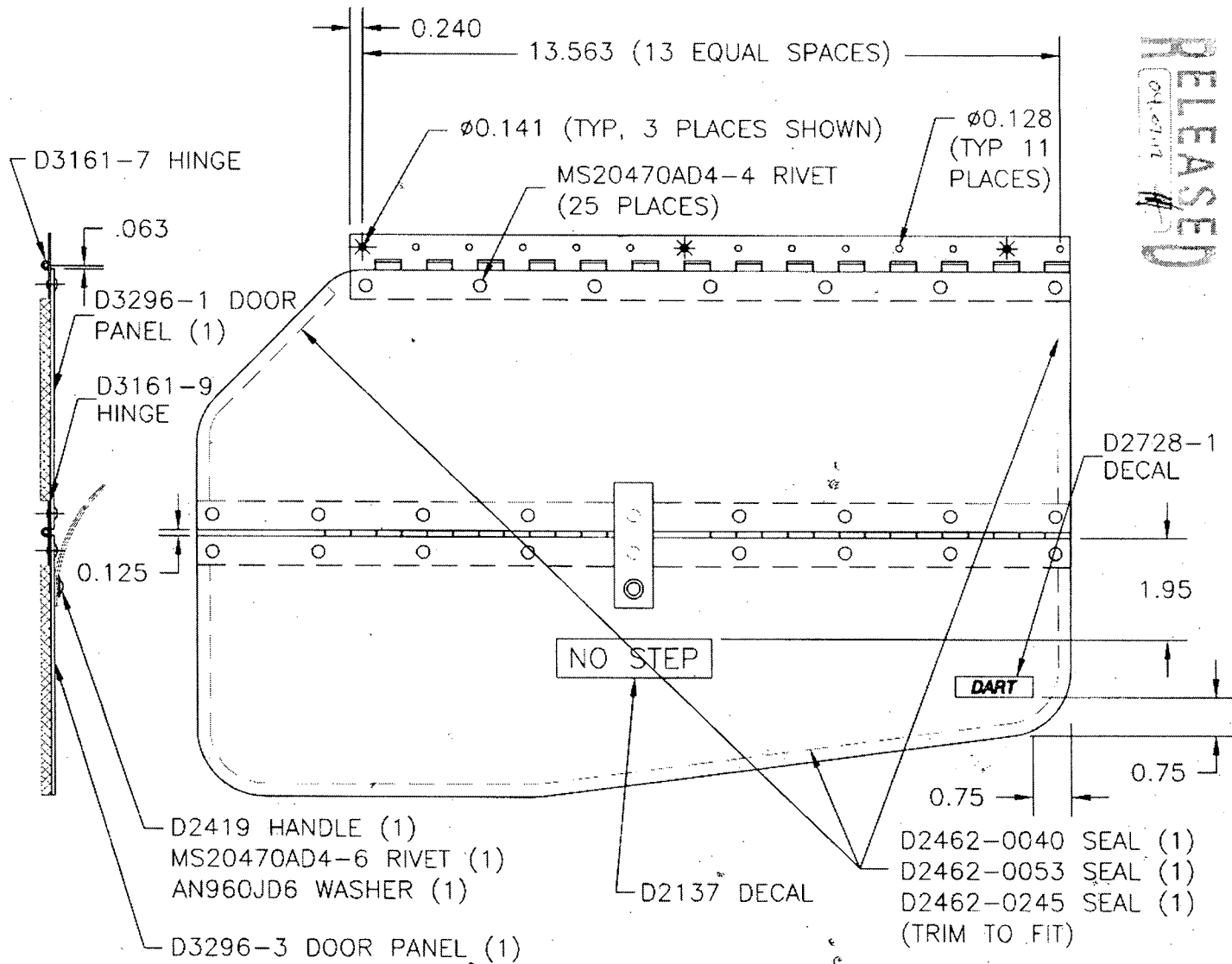
Shop Packet Print

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DESIGN	DRAWN BY	DART AEROSPACE LTD
04.06.28	04.06.28	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3296
DATE	TITLE	DOOR ASSEMBLY
04.06.28	NEW ISSUE	REV. A
A		1 OF 2
		SCALE 1:3

RELEASED

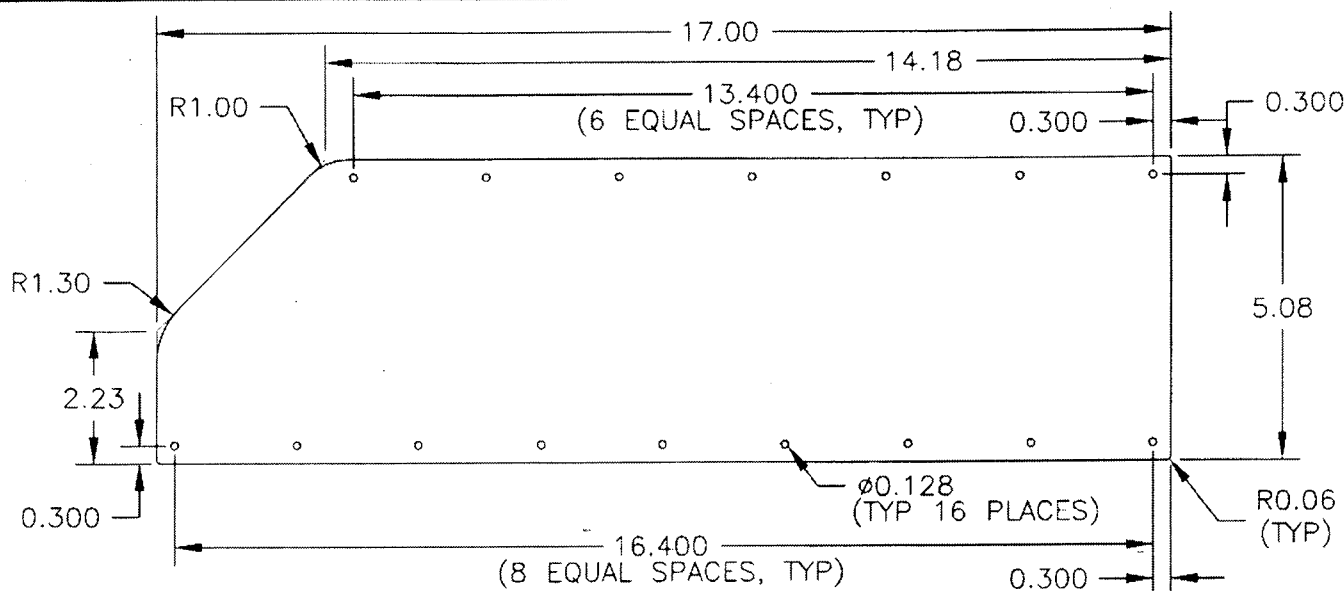


D3296-041 DOOR ASSEMBLY

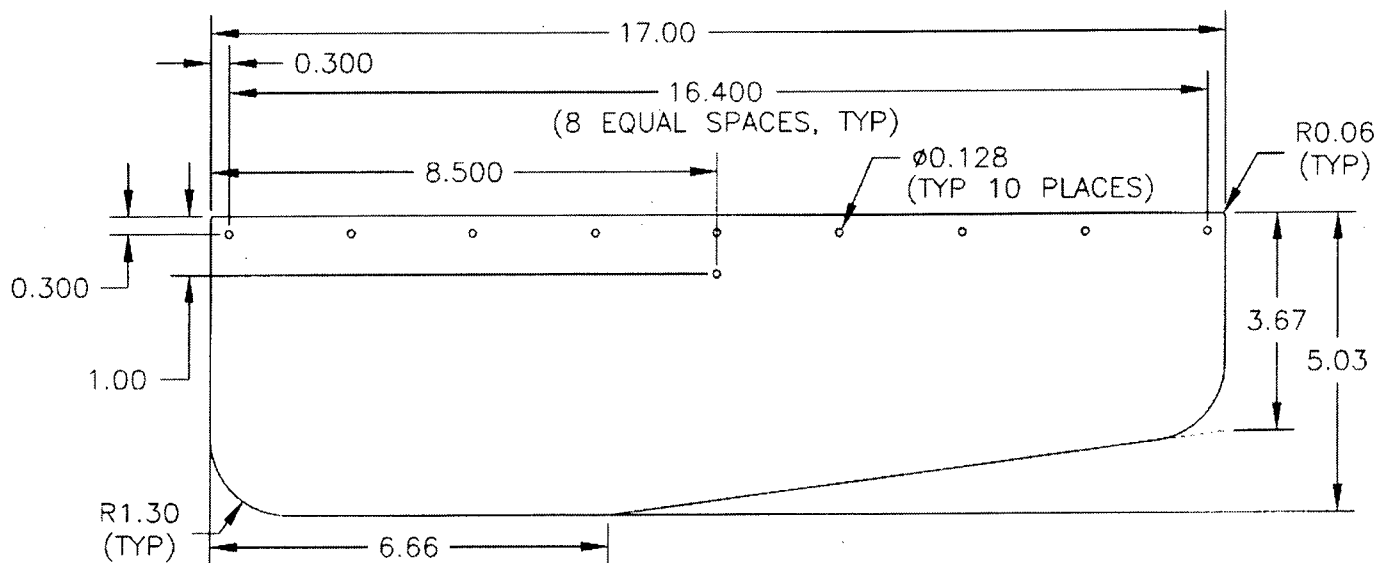
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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